

Date: Tuesday, 7/11/2006 1:05:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLATE
 Job Number : 27865
 Estimate Number : 10425
 P.O. Number : NIA Part Number : D32191
 This Issue : 7/11/2006 S.O. No. : NIA Drawing Number : D3219 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27592 Material : NIA
 Due Date : 7/18/2006 Qty: 40 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.07.11
 Comment : Est. A04.04.19 New issue KJJ/JLM
 ESR B 06.05.25 Waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.1012 sf(s)/Unit Total: 4.0488 sf(s)

6061-T6 .125 Sheet

To be made in multiples of 4

Material: 6061-T6 (QQ-A-200/11) 0.125" thick

(M6061T6S.125) Batch: 1101092

06 07 12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3219

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

06 07 12

(40)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 07 12

(40)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06-07-13 (38) 970

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: <i>N/A</i>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-13	4	2 parts scrap. Side damage (deep) from at the pierce point, too close to the hole, due to W.J. Splash back.	<i>[Signature]</i> <i>06-07-13</i>	destroy.	<i>SAD</i> <i>06-07-13</i>	<i>2</i> <i>06-07-13</i>	<i>[Signature]</i> <i>06-07-13</i>	<i>2</i> <i>06-07-13</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06.07.17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/11/2006 1:05:23 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 27865

Part Number: D32191

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

M.F. 06/07/13

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SB 06/07/12

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.17

Job Completion



U 06-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-13	6	QC 5 req'd. Perm. Change 2	SB	06/07/12	38	AB 06/07/13	2 06-07-13

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

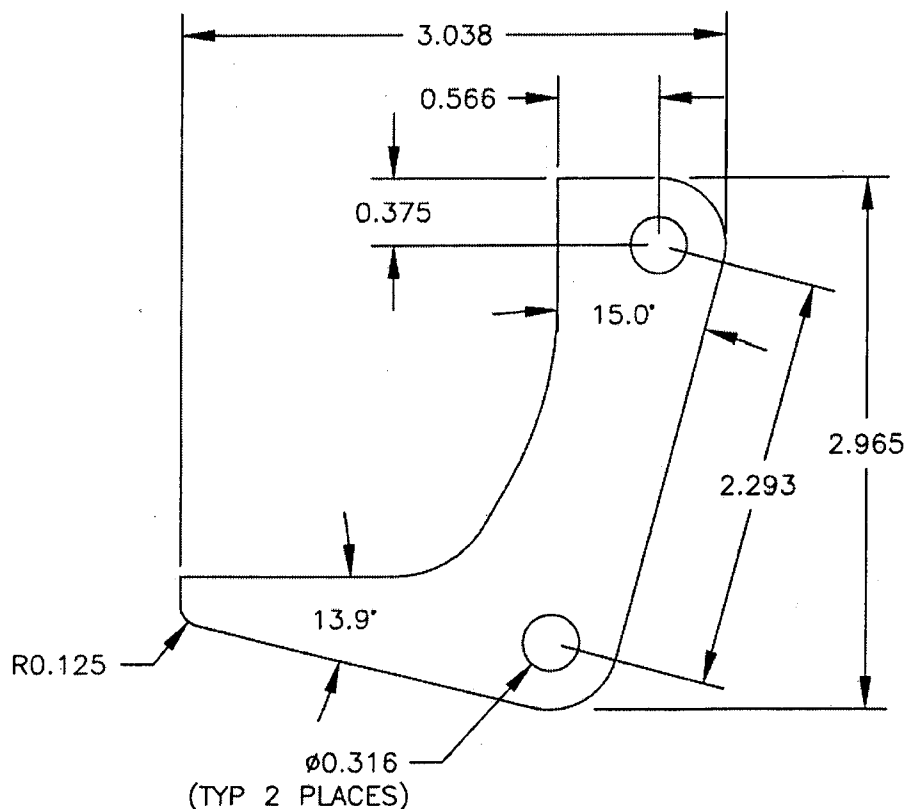
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05 *[Signature]*



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27865

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